

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016276**Date Inspected:** 02-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Guo Yan Fei, Chen Shi Gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 04, DECK PANEL REPAIR**13BW-DP3136-001**

During random in process inspection this QA inspector observed that ZPMC personnel were performing repair welding on the Partial Joint Penetration (PJP) weld joints of deck panel 13BW-DP3136-001. Welder is identified as 203805. ZPMC QC is identified as Mr. Zhang Hai Tao. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-Repair. The repair area details are as follows.

Weld: 001; Y location: 50

Weld: 002; Y location: 50, 1150

Weld: 006; Y location: 3550

Weld: 007; Y location: 50

Weld: 008; Y location: 50, 2350

Weld: 009; Y location: 50, 3550, 4750

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Weld: 010; Y location: 4150

Weld: 171; Y location: 4750

Weld: 173; Y location: 50

Weld: 178; Y location: 2950

Weld: 179; Y location: 50

Deck Panel: 13BE-DP3094(PL3190A)-001

This QA inspector observed that ZPMC NDT personnel Mr. Liu Zhang Min was performing Magnetic Particle Testing (MT) on the repair locations and coverage of NDT percentage of weld joint of deck panel 13BE-DP3094(PL3190A)-001.

BAY 09, U-rib Internal Cover Plate

FCAW welding of weld joint 385 located on DP3159-001.

Welder is identified as 059421. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 376 located on DP3159-001.

Welder is identified as 059421. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 325 located on DP3159-001.

Welder is identified as 059416. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 332 located on DP3159-001.

Welder is identified as 059416. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 339 located on DP3162-001.

Welder is identified as 059421. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 346 located on DP3162-001.

Welder is identified as 059421. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 399 located on DP3162-001.

Welder is identified as 059416. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 382 located on DP3162-001.

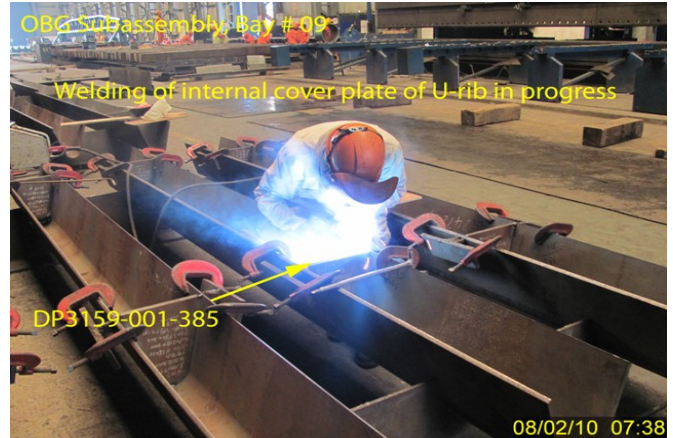
Welder is identified as 059416. ZPMC QC is identified as Mr. Zhu Zhong Jie.

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The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer